

# Work Order ID 86111

June-20-12 2:52:19 PM

**\*86111\***

Page 1

Item ID: D3255-2

Accept

**\*N900040100\***

Setup Start **\*NS1\***

Revision ID:

Stop **\*NS2\***

Item Name: Panel

Start Date: 20/06/2012 Start Qty: 6.00

**\*6\***

Cust Item ID:

Required Date: 04/07/2012 Req'd Qty: 6.00

**\*6\***

Customer:

Reference:

Approvals: Process Plan: MLJ Date: 12/06/12 Tooling:

Run Start **\*NR1\***

QC: Date: SPC (Y/N):

Date: Stop **\*NR2\***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr	Revision Nbr
D3255	Rev B

100 0.00

**\*100\***

FLOW WATER JET

Waterjet

Memo

0.00

FLOW CNC Waterjet

1-Cut as per Dwg D3255 Dwg Rev: B Prog Rev: B 2-  
Deburr if necessary

304 .032

B12-6-26

110 0.00

**\*110\***

QC2- Inspect parts off machine FAI/FAIB

QC

Memo

0.00

Quality Control

B12-6-26

120 0.00

**\*120\***

QC8- Inspect parts - second check

QC

Memo

0.00

Quality Control

5/7/06/27

78

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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**NOTE:** Date & initial all entries

**\*86111\***

Page 2

**Accept**

\*N900040100\*

Setup Start \*NS1\*

Stop \*NS2\*

**Cust Item ID:**

**Start Date:** 20/06/2012      **Start Qty:** 6.00

\*6\*

**Customer:**

**Required Date:** 04/07/2012      **Req'd Qty:** 6.00

\*6\*

**Reference:**

**Approvals:**      **Process Plan:** \_\_\_\_\_ **Date:** \_\_\_\_\_ **Tooling:** \_\_\_\_\_ **Date:** \_\_\_\_\_ **Run** **Start** **\*NR1\***  
                  **QC:** \_\_\_\_\_ **Date:** \_\_\_\_\_ **SPC (Y/N):** \_\_\_\_\_ **Date:** \_\_\_\_\_ **Stop** **\*NR2\***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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130

\*130\*

Brake NC

NC BRAKE

## Memo

0.00

0.00

Form as per Dwg D3255

140

\*140\*

QC

QC5- Inspect part completeness to step on W/O

## Memo

0.00

0.00

## Quality Control

150

**\*150\***

## Packaging

## Packaging

Identify as per dwg & Stock Location: 176

## Memo

0.00

0.00

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**Work Order ID 86111****\*86111\***

Page 3

June-20-12 2:52:19 PM

Item ID: D3255-2

Accept

**\*N900040100\***

Setup Start

**\*NS1\***

Revision ID:

Stop

**\*NS2\***

Item Name: Panel

Start Date: 20/06/2012 Start Qty: 6.00

**\*6\***

Cust Item ID:

Required Date: 04/07/2012 Req'd Qty: 6.00

**\*6\***

Customer:

Reference:

Approvals: Process Plan: Date:

Tooling:

Date:

Run Start

**\*NR1\***

QC: Date:

SPC (Y/N):

Date:

Stop

**\*NR2\***Sequence ID/  
Work Center IDOperation  
DescriptionSet Up/  
Run Hours

Tool ID

Tool #

Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

160

QC21- Final Inspection - Work Order Release

0.00

**\*160\***

QC

Memo

0.00

Quality Control

CK 12/7/11

MF  
12-07-10

W/O:		WORK ORDER CHANGES					
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**NOTE:** Date & initial all entries

# Picklist Print

June-20-12 2:52:23 PM

Page 1

Work Order ID: 86111

\*86111\*

Parent Item: D3255-2

\*D3255-2\*

Parent Item Name: Panel

Start Date: 20/06/2012

Required Date: 04/07/2012

Start Qty: 6.00

Required Qty: 6.00

Comments: IPP Rev:A New Issue 06-08-01 JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M304S22GA		Purchased	No			100	sf	236.9900	1.484	9.372632	13,		

\*M304S22GA\*

304/316 .032 Sheet

\*\*

B12-6-2C

Location

Loc Qty

Loc Code

MAT020

236.99

118271

8.88

120866

74.36

121889

153.75

120866

8

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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**NOTE:** Date & initial all entries



<b>DART AEROSPACE LTD</b>		<b>Work Order:</b>	26111
<b>Description:</b> Access Panel Assembly		<b>Part Number:</b>	D3255-2
<b>Inspection Dwg:</b> D3255 <b>Rev:</b> B		<b>Page 1 of 1</b>	

### FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article      ☐ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
Ø0.098	+0.004/-0.001	.100	2		V	
15.171	+/-0.010	15.171	2		T 1367	
10.032	+/-0.010	10.035	2		T	
6.902	+/-0.010	6.907	1		T	
18.456	+/-0.010	18.456	1		T	
11.432	+/-0.010	11.435	2		V Bo2	
2.261	+/-0.010	2.261	2		V	
2.363	+/-0.010	2.355	2		V	
2.363	+/-0.010	2.358	2		V	
1.183	+/-0.010	1.189	2		V	
0.250	+/-0.010	.251	2		V	
0.250	+/-0.010	.251	2		V	
2.261	+/-0.010	2.261	2		V	

<b>Measured by:</b> RB	<b>Audited by:</b> S	<b>Prototype Approval:</b>	N/A
<b>Date:</b> 12-6-20	<b>Date:</b> 12/06/27	<b>Date:</b>	N/A

Rev	Date	Change	Revised by	Approved
A	08.05.06	New Issue	KJ/DD	DD

# Dart Aerospace Ltd

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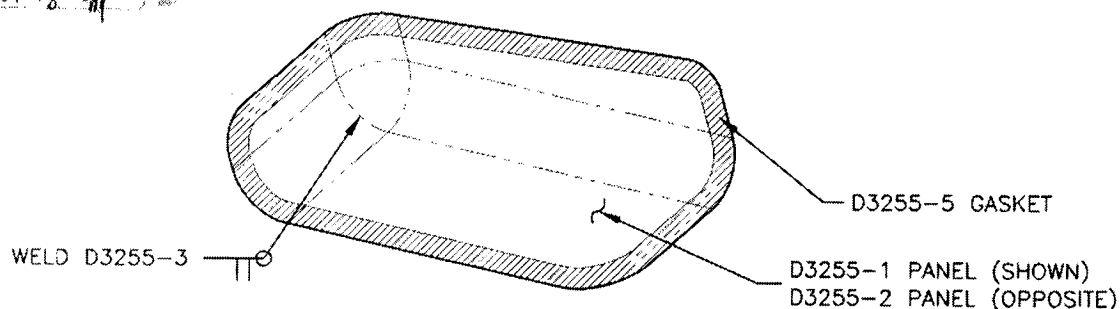
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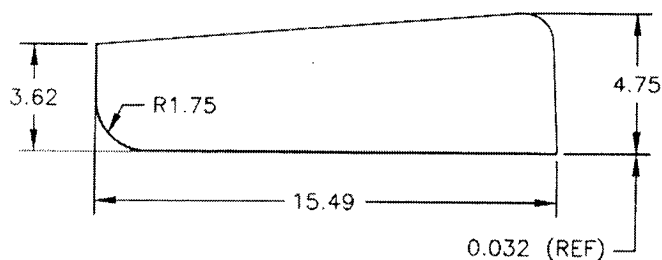
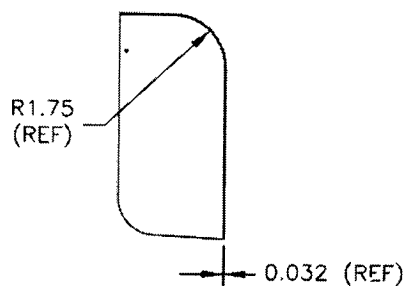
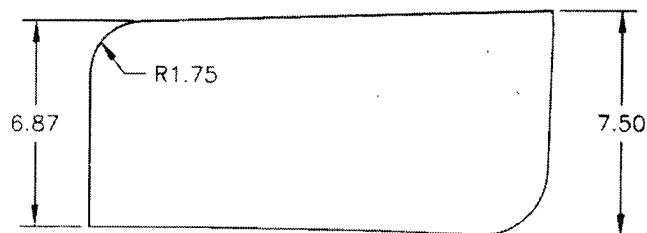


DESIGN TJ	DRAWN BY TJ	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED if	APPROVED [Signature]	DRAWING NO. D3255	REV. B SHEET 1 OF 4
DATE 04.12.06		TITLE ACCESS PANEL ASSEMBLY	SCALE 1:6
A	04.01.27	NEW ISSUE	
B	04.12.06	D3255-3 REDESIGN; ADDED $\phi 0.098$	

RELEASED  
05-01-18 [Signature]



**D3255-041 ACCESS PANEL (SHOWN)**  
**D3255-042 ACCESS PANEL (OPPOSITE)**



**D3255-1 BEND DETAIL**  
**D3255-2 OPPOSITE**

**D3255-041/-042 NOTES:**

- 1) WELD PER DART QSI 004
- 2) FINISH: POWDER COAT GREY SANDTEX (4.3.5.6) PER QSI 005 4.3
- 3) INSTALL D3255-5 GASKET USING DOW CORNING P/N 736 ADHESIVE IN ACCORDANCE WITH MANUFACTURE'S INSTRUCTIONS
- 4) IDENTIFY WITH P/N & B/N USING FINE POINT PERMANENT MARKER

SHOP COPY  
RETURN TO  
ENGINEERING  
UNCONTROLLED COPY  
SUBJECT TO AMENDMENT  
WITHOUT NOTICE  
WORK ORDER  
NO. 26111  
12/06/20

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# Dart Aerospace Ltd

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Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

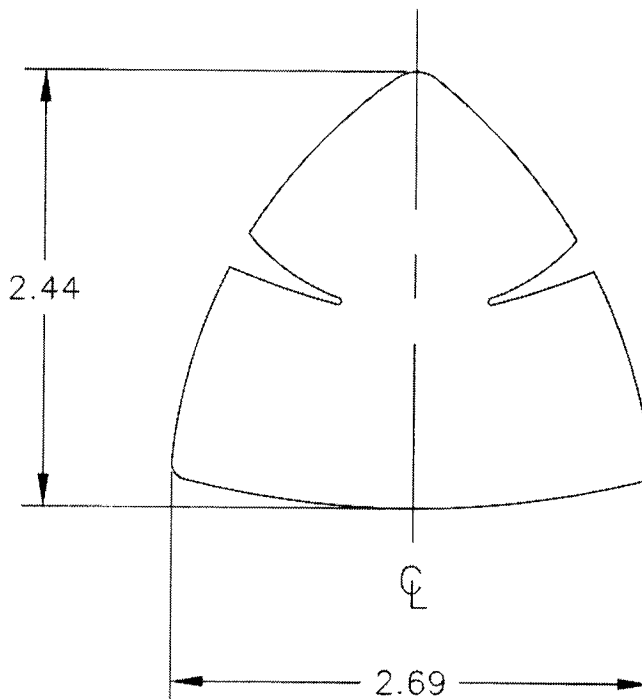
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CHECKED JP	APPROVED JF	DRAWING NO. D3255	REV. B SHEET 2 OF 4
DATE 04.12.06		TITLE TITLE	SCALE 1:1

RELEASED  
05.01.08



**D3255-3 CAP**  
**FORM TO FIT D3155-1/-2**

**D3255-3 NOTES:**

- 1) MATERIAL: AISI 304/316 SS 0.032 THICK (REF. M304S22GA)
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 3) ALL DIMENSIONS ARE IN INCHES
- 5) BREAK ALL SHARP EDGES 0.005 TO 0.010
- 6) MAKE PER DRAWING "D3255-B2.DWG"

2011

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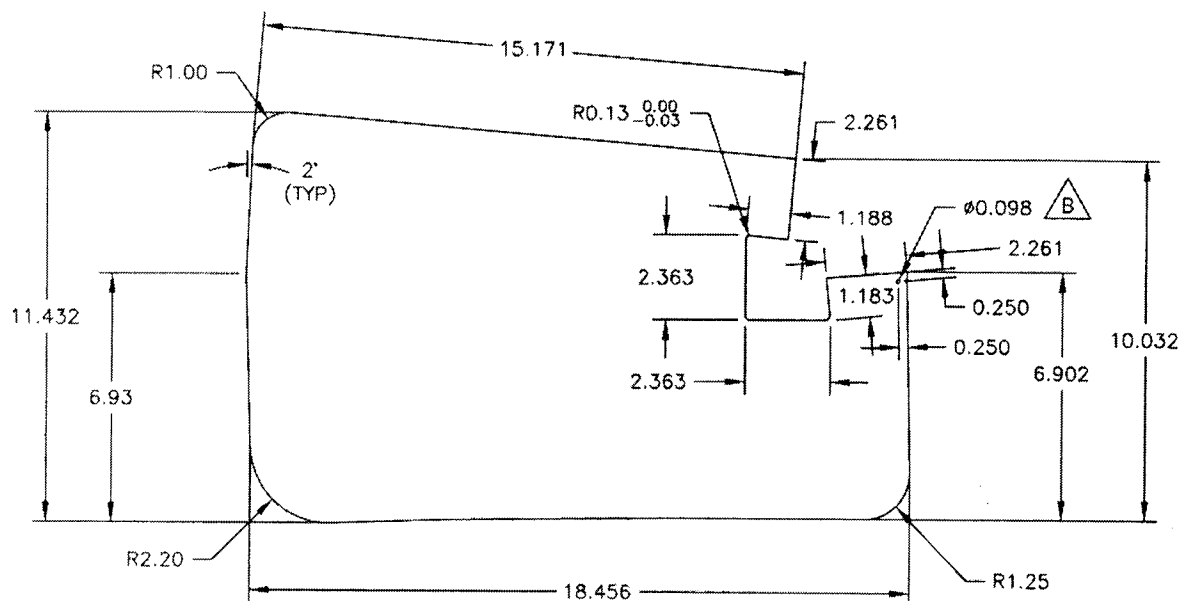
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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries



DESIGN TF	DRAWN BY TF	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED CP	APPROVED H	DRAWING NO. D3255	REV. B SHEET 3 OF 4
DATE 04.12.06		TITLE ACCESS PANEL ASSEMBLY	SCALE 1:5

RELEASED  
05-01-18



### D3255-1/-2 FLAT PATTERN

#### D3255-1/-2 NOTES:

- 1) MATERIAL: AISI 304/316 SS 0.032 THICK (REF. M304S22GA)
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) BREAK ALL SHARP EDGES 0.005 TO 0.010

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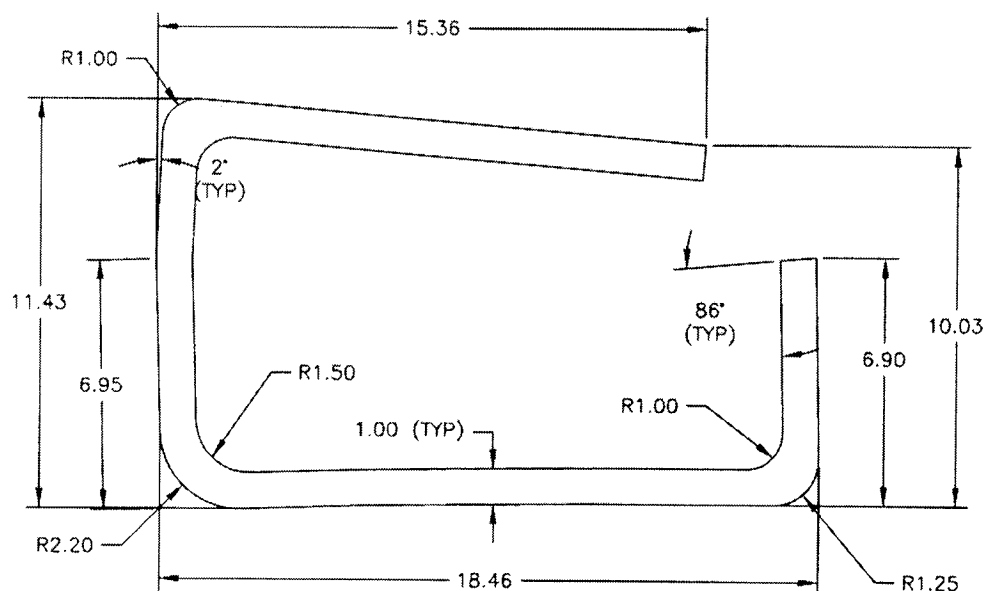
**NOTE:** Date & initial all entries





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CHECKED LP	APPROVED TJ	DRAWING NO. D3255	REV. B SHEET 4 OF 4
DATE 04.12.06		TITLE ACCESS PANEL ASSEMBLY	SCALE 1:5

RELEASED  
05 01.18 #



### D3255-5 GASKET

#### D3255-5 NOTES:

- 1) MATERIAL: SILICONE COATED FIBERGLASS CLOTH PER AMS 3320F  
P/N SIL/F 36x36x1/16  
POSSIBLE SUPPLIER: AVIALL
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 3) ALL DIMENSIONS ARE IN INCHES

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